

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010072**Date Inspected:** 17-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay11, South Tower, Strut Plate.

SMAW Repair welding of weld joint SD1-A6002-1-9A(CWR # T-CWR263); located on Bay11, South Tower. Welders are identified as 040611; ZPMC Quality Control Inspector (QC) is identified as Yu Dong Ping. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-2G(2F)-FCM-1-Repair.

Bay 11, West tower, Lift 1 & 2.

AB/F carried out Magnetic Particle Testing (MT) Inside.

Bay11, West Tower, Interior Splice Plate Repair.

Repair gouge outs noticed on Interior Splice Plate, weld Identified as SSD1-SPSA3-5-6-2B. See attached picture for details.

Bay11, North Tower, Lift 3.

Repair gouge outs noticed on North Tower, Lift 3, Skin B. There as No Access Available, so this QA could not take dimensional measurements. See attached pictures for details.

Bay10, West Tower, Corner Angle Plate.

SMAW Repair welding of weld joint WD1-A5012-14-1B(WRR # T-WR2485); located on Bay10, West Tower.

Welders are identified as 053049; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The

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welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-2G(2F)-FCM-Repair.

Bay10, North Tower, Corner Angle Plate.

SMAW Repair welding of weld joint ND1-A5002-25-1B(WRR # T-WR2490); located on Bay10, North Tower.

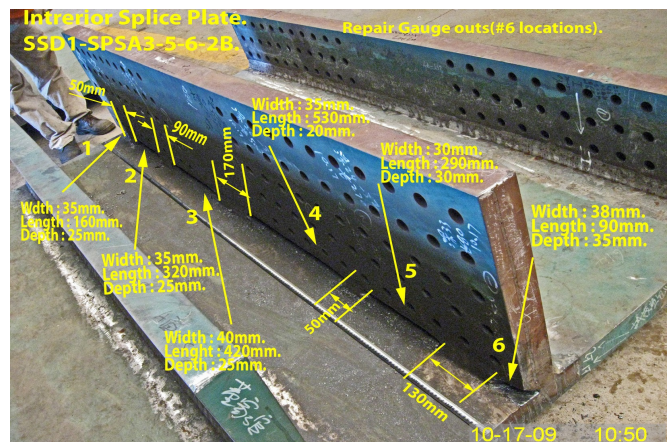
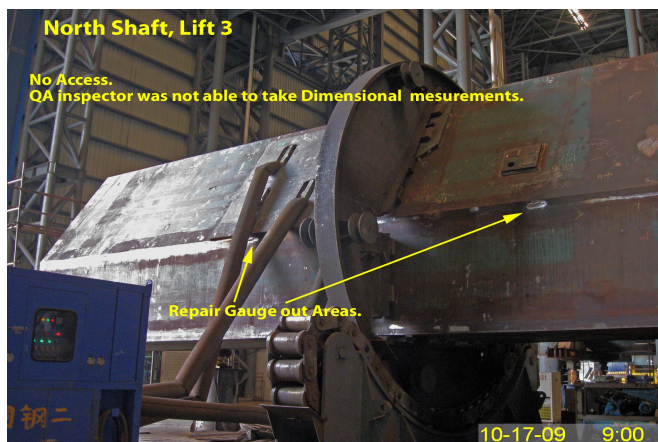
Welders are identified as 056200; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-485-SMAW-2G(2F)-FCM-Repair.

This QA Inspector carried out NDE on following

Bay 11, North Tower, Lift 3, Corner BC, CD Stiffener.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as NSTL3-3K/K-8, 27.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
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<b>Reviewed By:</b>	Clifford,William	QA Reviewer
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